

Date: Monday, 3/26/2007 3:23:12 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FITTING		
Job Number	: 31485					
Estimate Number	: 10844					
P.O. Number	: N/A		Part Number	: D2249041		
This Issue	: 3/26/2007	S.O. No.	: N/A	Drawing Number	: D2249 REV. E	
Prsht Rev.	: NC	Type	: SMALL /MED FAB	Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: E		
Previous Run	: 31031		Material	: N/A		
Written By			Due Date	: 4/10/2007		
Checked & Approved By			Qty:	4 Um: Each		
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	31485A	LUG		
		Comment: Sub-Component LUG D2249-1 B <u>31609</u>		FC
2.0	31485B	LUG		
		Comment: Sub-Component LUG D2249-3 B <u>11016</u>		FC
3.0	31485C	GUSSET		
		Comment: Sub-Component GUSSET D2249-5 B <u>31609</u>		FC
4.0	D22491	Lug		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Lug Pick: Qty Part Number Description Batch 1 D2249-1 Lug <u>31609</u>		FC
5.0	D22493	Base Plate		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Base Plate Pick: Qty Part Number Description Batch 1 D2249-3 Base Plate <u>11016</u>		FC 07 07 03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 5/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:23:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 31485

Part Number: D2249041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D22495 Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gusset

(2) D2249-5 blanks per (1) D2249-041

Pick:

Qty	Part Number	Description	Batch
2	D2249-5	Gusset	31609

FC 07/07/03

7.0 LARGE FAB 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2249 and QSI 004

FC 07/07/03 (4)

8.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

07/07/03 (4)

9.0 POWDER COATING



M 104 144

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

BL/m-d 07-07-03 (4)

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/07/04 (4)

11.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57010

07/07/04 (4)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/04

Job Completion



07-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

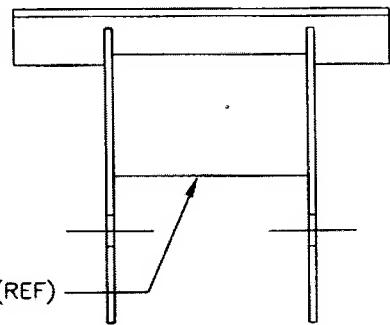
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

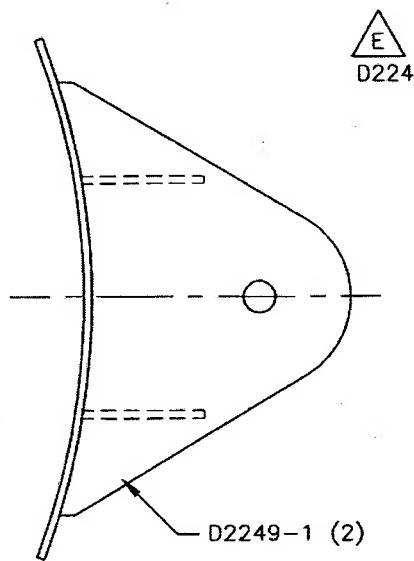
NOTE: Date & initial all entries

DART**RELEASED**94.10.12
KE

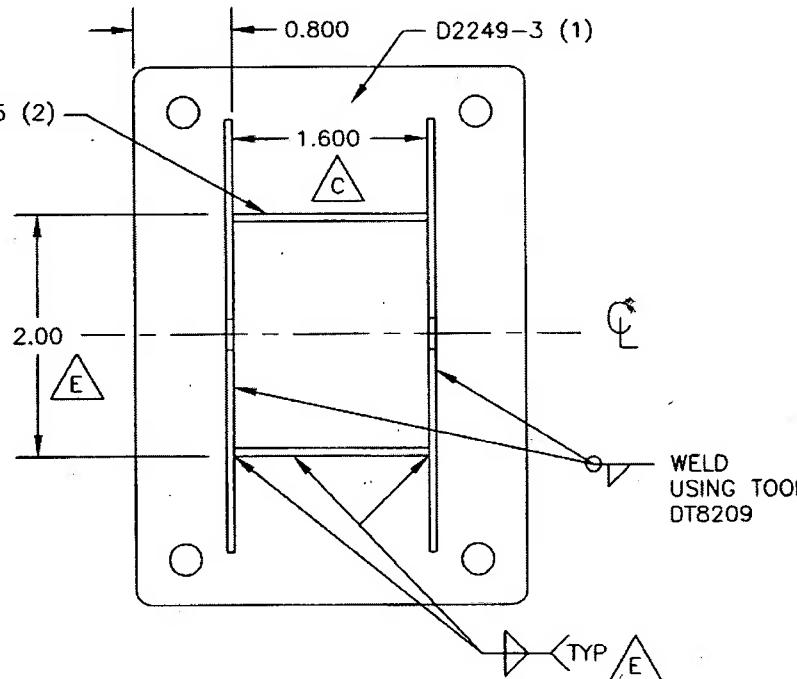
DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED W	DRAWING NO. D2249	SHEET 1 OF 4
DATE 99.09.20	TITLE FITTING	SCALE NTS	
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	FITTING	
D	98.04.30	$\phi 0.261$ WAS $\phi 0.257$ (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



E D2249-5 (REF)



E D2249-5 (2)

D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

ALL DIMENSIONS ARE IN INCHES

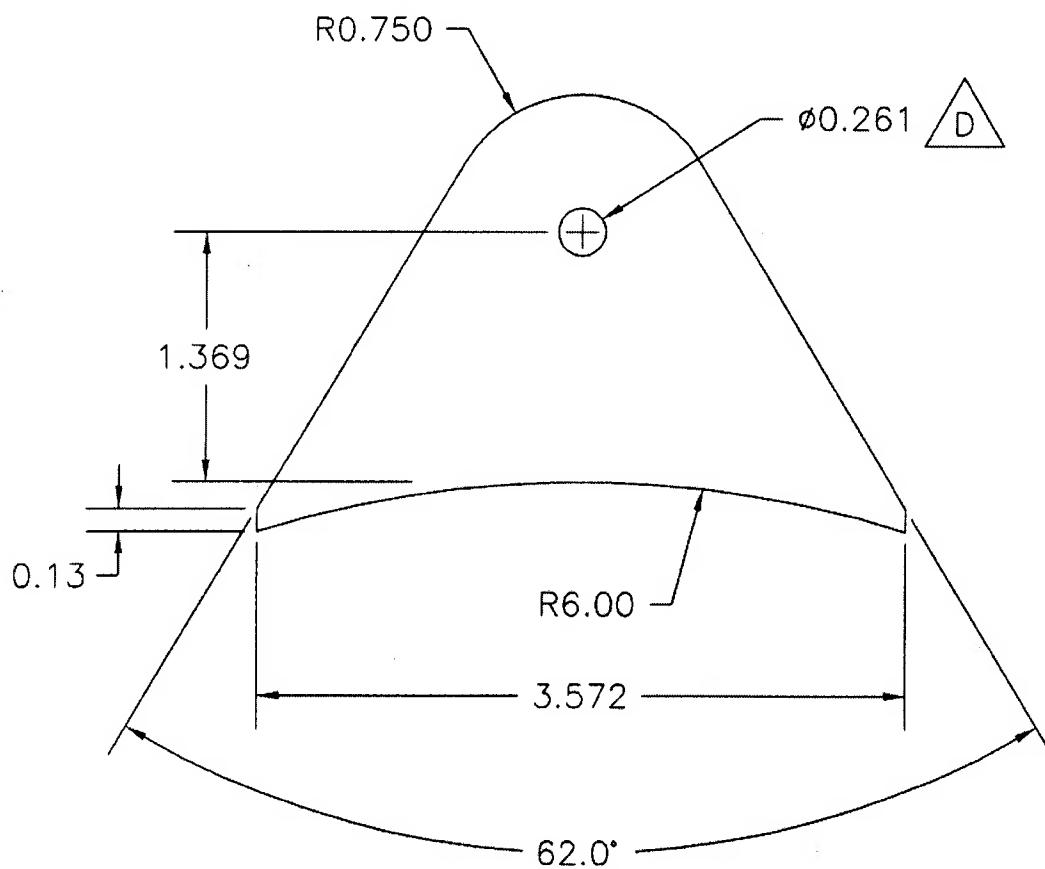
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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WORK ORDER
NO. 21485

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
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WORK ORDER

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 3 OF 4 1:1

RELEASED
99.10.12 KE

99.10.12 KE

99.10.12 KE

Ø0.261 (TYP)



R0.125 (TYP)

4.44

3.690



2.400

0.375 (TYP)

3.20

0.400 (TYP)

FLAT PATTERND2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

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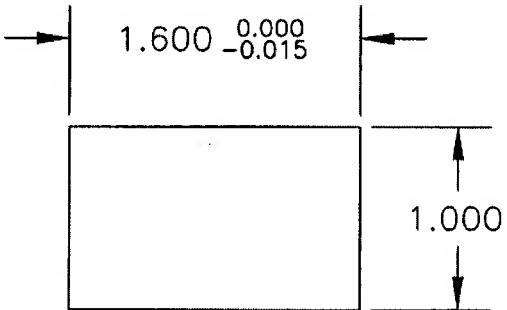
NO. 31485

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AL</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED

19.10.12 KE

D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. *31485*
WORK ORDER